V	or	k O	rder	ID	66573
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Page 1 Tuesday, February 22, 2011 11:00:12 AM Item ID: D3255-1 Accept Setup Start **Revision ID:** Stop Item Name: Panel Start Qty: 4.00 **Start Date:** 2/23/2011 **Cust Item ID:** Required Date: 3/9/2011 Req'd Qty: 4.00 **Customer:** Reference: Run Start Date: 1/-02-22-Tooling: Process Plan: Approvals: Date: Stop Date:_____ QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Reject Tool # Plan Accept **Work Center ID** Description Run Hours Qty Number Stamp Code Qty Draw Nbr **Revision Nbr** D3255 Rev B 100 0.00 FLOW WATER JET BU-2-23 Waterjet 0.00 Memo \$ □Prog Rev: B □2-FLOW CNC Waterjet 1-Cut as per Dwg D3255 □Dwg Rev: Deburr if necessary 304,035 110 QC2- Inspect parts off machine FAI/FAIB 0.00 4B(1-2-23 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00

Quality Control

QC

Memo

Valua 3000

Dart Aerospace Ltd	rospace Ltd
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	gory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	n:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCI	₹)			
	l	Description of NC	Corrective Action				cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
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Page 2

Tuesday, February 22, 2011 11:00:12 AM

Item ID:

D3255-1

Revision ID:

Item Name: Panel

Start Date:

2/23/2011



Accept

Setup Start

Stop



Start Qty: 4.00 **Cust Item ID:** Required Date: 3/9/2011 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals:

QC:

Process Plan: Date:

Date: _____

Tooling:

SPC (Y/N):

Date:

Tool ID

Date:

Run Start

Stop



Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

Form as per Dwg D3255

Set Up/ **Run Hours**

0.00

Sn 11/03/02

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

140

Quality Control

QC5- Inspect part completeness to step on W/O

Dul03/02

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150

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

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W/O:			W	ORK ORDER CHANG	SES				<u> </u>	
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•	PAR #:	Fault Category:			NCR: Yes No DQA:				
Resolution:			Disposition	Disposition: QA			QA: N/C Closed:			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	CR)				
DATE	STEP	Description of NC	Corrective Action		tion B		ication	Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Da		tion C	Chief Eng	QC Inspector	
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Work Order ID 66573

Page 3

Item ID:

D3255-1

Tuesday, February 22, 2011 11:00:12 AM

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 3/9/2011

Panel

Start Qty: 4.00 2/23/2011

Req'd Qty: 4.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

QC:

Process Plan:

Date: Date: **Tooling:**

Date:

Date:

Run Start



Sequence ID/

Work Center ID

160

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

SPC (Y/N):

0.00

Tool # Plan Code

Accept Qty

Reject Reject Qty

Stop

Insp. Number Stamp

Memo

0.00

Quality Control

W/O:			WO	RK ORDER CHANG	EC				
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	Date: _					
	Res	solution:	Disposition	:	QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NCR	1)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	tion B Sign & Date		Verification Section C Approva		Approval QC Inspector
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Picklist Print

Tuesday, February 22, 2011 11:00:09 AM

Work Order ID: 66573

Parent Item: D3255-1

Parent Item Name: Panel



Start Date: 2/23/2011

Required Date: 3/9/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA	Sili Sook ibi ibsi	Purchased	No			100	sf	61.2896	1.484	6.248421			

304/316 .032 Sheet

Location	Loc Qty	Loc Code
MAT20	61.2896	
109023	30.2896	
109057	31	

1811-2-23

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W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
		solution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
		Description of NC	Description of NC Corrective Ac		ion Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sign & Section C Date		Chief Eng	QC Inspector

NOTE: Date & initial all entries

A ST.

DART AEROSPACE LTD	Work Order: 66573	
Description: Access Panel Assembly	Part Number: D3255-	<u> </u>
Inspection Dwg: D3255 Rev: B	Page 1 of	1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Kejeci	Inspection	Comments
Ø0.098	+0.004/-0.001	401.	2		V BOZ	
15.171	+/-0.010	15.171	80		T BOT	
10.032	+/-0.010	10 030	っ		7	
6.902	+/-0.010	6,909	>		1	
18.456	+/-0.010	18,456	ــــــــــــــــــــــــــــــــــــــ		7	
11.432	+/-0.010	11,440	×		4	
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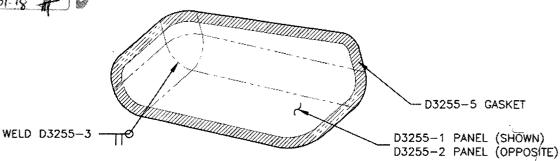
Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	11-9-93	Date: 11/02/	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM	

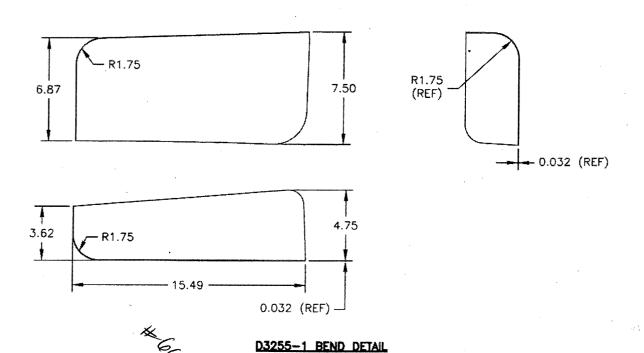
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W/O:			WO	RK ORDER CHANGE	S				* * * * * * * * * * * * * * * * * * * *
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No: PAR #: Resolution:									
		esolution:	Disposition	QA: N/C Cl	A: N/C Closed:				
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DATE	STEP	Description of NC	Corrective Action Section B			Verifica	Verification		Approval
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	DATE		······································	TITLE SCALE
	04.1	12.06 🗼		ACCESS PANEL ASSEMBLY 1:6
	A	·.	04.01.27	NEW ISSUE
	В	•	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



- D3255-041/-042 NOTES:
 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

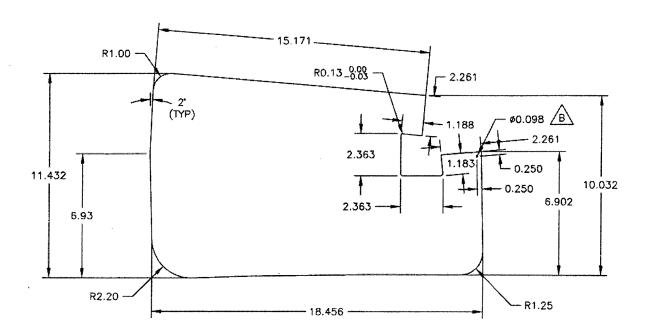
D3255-2 OPPOSITE

									
W/O:			WO	RK ORDER CHANG	iES				· · · · · · · · · · · · · · · · · · ·
DATE STEP		PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Ye	s No D O	A:	Date: _	
Resolution:		Disposition	_ QA: N/C	QA: N/C Closed:			Date:		
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DATE	STEP	Description of NC	Corrective Action Section				ication	Approval	Approval
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DESIGN F	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHECKED	APPROVEO	DRAWING NO.	REV. B
41	#	D3255	SHEET 3 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5







D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _			
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	STEP	Description of NC		Corrective Action Section B		Verification		Approval	Approval		
DATE		STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	Section C	Chief Eng	QC Inspector		
	1										